

**Work Order ID 52618**

October 5, 2009 8:09:20 AM

DS/10



Page 1

Item ID: D3163-041 *GY*

Revision ID: D

Item Name: Cover Assembly

Start Date: 10/05/09 Start Qty: 3.00



Required Date: 10/06/09 Req'd Qty: 3.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3163

Rev D

0.00

100



Small Fab

0.00

Small Fab

Memo

Rivet D3163-3 to D3163-1  
Ensure holes line up

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

0.00

120



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

0.00

 Memo  
 START TIME: 11:15  
 OVEN TEMPERATURE: 328°  
 FINISH TIME: 11:45

# Work Order ID 52618

October 5, 2009 8:09:20 AM



Page 2

Item ID: D3163-041

Revision ID: D

Item Name: Cover Assembly

Start Date: 10/05/09 Start Qty: 3.00



Required Date: 10/06/09 Req'd Qty: 3.00



Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Setup Start



Stop



Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

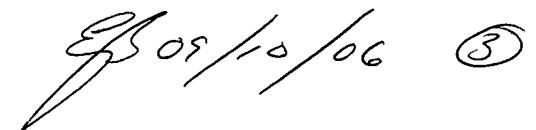
Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

0.00

 8/09/10/06 (3)

140



Small Fab

Small Fab

0.00

0.00

 8/09/10/06 (3)

150



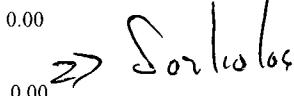
QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

 8/09/10/06

(3) f

**Work Order ID 52618**

October 5, 2009 8:09:21 AM



Page 3

**Item ID:** D3163-041**Accept****Setup Start****Revision ID:** D**Stop****Item Name:** Cover Assembly**Start Date:** 10/05/09 **Start Qty:** 3.00**Cust Item ID:****Required Date:** 10/06/09 **Req'd Qty:** 3.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/  
Work Center ID****Operation  
Description**

160



Packaging

Identify as per dwg &amp; Stock Location:

COMP

Packaging

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/10/06

Memo

0.00

09/10/07

Memo

0.00

W 9.10.07

# Picklist Print

October 5, 2009 8:09:19 AM

Page 1

Work Order ID: 52618



Parent Item: D3163-041RevD



Parent Item Name: Cover Assembly

Start Date: 10/05/09

Required Date: 10/06/09

Comments:

Start Qty: 3.00

Required Qty: 3.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3163-1RevD



Plate

Manufactured

No

100 Each 2.0000 3.0000



Ep09/10/09  
B 52621 (3A)

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

50398

2

2

100

Each

0.0000 3.0000

B 52617 (3x)



Ep09/10/09

D3163-3RevD



Plate

Manufactured

No

4197

50398

100

Each

0.0000 3.0000

B 52617 (3x)



Ep09/10/09

MS20426AD3-4



RIVET

Purchased

No

4000

104374

110398

140

8,197.000 12.0000



Ep09/10/09

MS20426AD3-4



RIVET

Purchased

No

4197

104374

110398

140

8,197.000 12.0000



Ep09/10/09

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

8197

104374

110398

140

4197



12

4000

# Picklist Print

October 5, 2009 8:09:19 AM

Page 2

Work Order ID: 52618



Parent Item: D3163-041RevD



Parent Item Name: Cover Assembly

Start Date: 10/05/09

Required Date: 10/06/09

Comments:

Start Qty: 3.00

Required Qty: 3.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21059L08<br>                  |                        | Purchased     |             | No                  |                  | 140             | Each               | 229.0000       | 6.0000                   |               | EF09/10/06     |        |

Nut

Warehouse

Location

Main Warehouse

|        |     |  |
|--------|-----|--|
| ST     | 229 |  |
| 112314 | 200 |  |
| 12706  | 29  |  |

Loc Qty

Loc Code

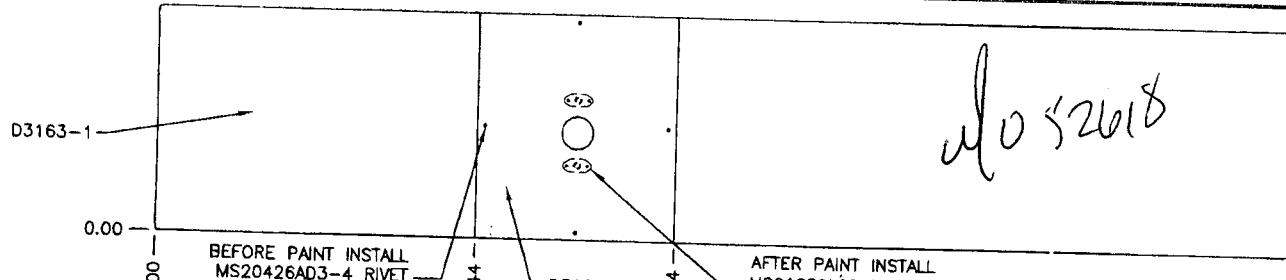
 

6

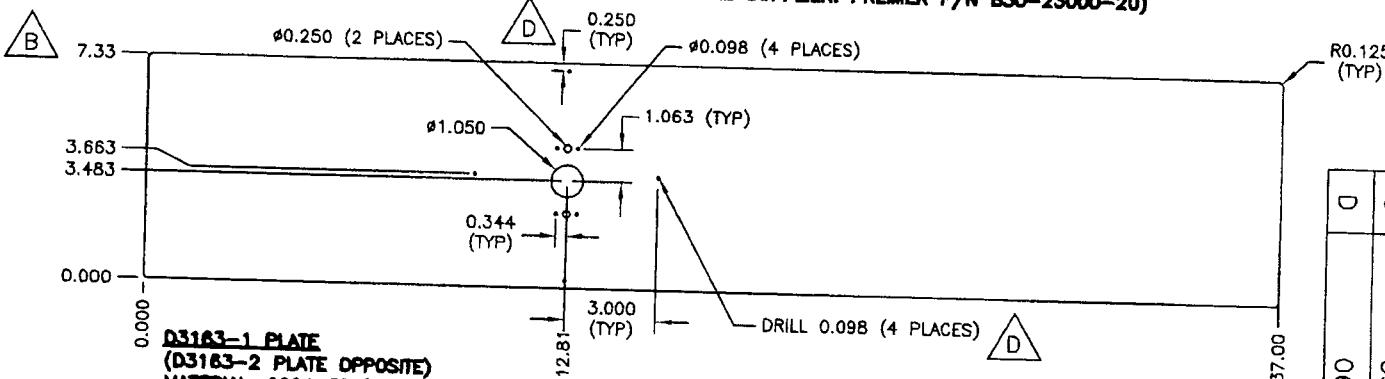
**DART**

**RELEASED**  
06-06-29

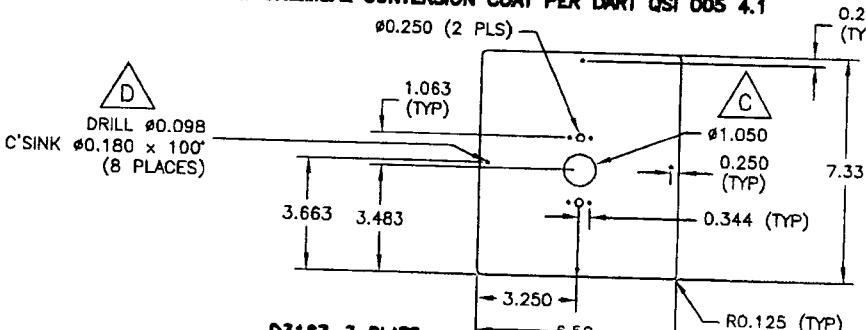
| DESIGN<br>RF | DRAWN BY<br>CB | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|--------------|----------------|---|
| CHECKED      | APPROVED       | DRAWING NO.                                       |
| DATE         | REV. D         | SHEET 1 OF 1                                      |
| 06.06.26     | <i>SH</i>      | D3163   |
| A            | 02.04.26       | NEW ISSUE   |
| B            | 04.10.06       | 7.33 WAS 7:20; REMOVE PERIMETER<br>HOLES          |
| C            | 05.11.22       | Ø1.050 WAS Ø1.000                                 |
| D            | 06.06.26       | ADD 4 RIVETS; REMOVE ADHESIVE                     |



**D3163-041 PLATE SHOWN, POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19  
(D3163-042 PLATE OPPOSITE, POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)**



**D3163-1 PLATE  
(D3163-2 PLATE OPPOSITE)**  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR  
8081-T8 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M8081T8S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



**D3163-3 PLATE**  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR  
8081-T8 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M8081T8S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

**GENERAL NOTES:**

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER